

Derew - 55161
Work Order ID 53712 = split 2

November 13, 2009 9:56:05 AM

Page 1

Item ID: D3594-043

Revision ID: B

Item Name: Floor Doubler Assembly, LH

Start Date: 13/11/2009 Start Qty: 1.00

Required Date: 20/11/2009 Req'd Qty: 7.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals:

Process Plan:

Date: 09-11-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3594

Rev B

0.00

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3594
Deburr if necessary

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

110



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

120



QC

Quality Control

27802/11/18

B 9-11-18

B 9-11-18

(KS)

Work Order ID 53712

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Page 2

Item ID: D3594-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Floor Doubler Assembly, LH

Start Date: 13/11/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 7.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

C'SINK AS PER DWG D3594

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

09/11/23 ⑧

④③
④⑤

=> 8 09/11/23

md 09/11/30

X8

Work Order ID 53712

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Page 3

Item ID: D3594-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Floor Doubler Assembly, LH

Start Date: 13/11/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 7.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev. Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

0.00

0.00

0.00

0.00

170



Small Fab

Small Fab

Small Fab

Memo

Install Nut Plates As per Dwg D3594

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

PK 009-11-30

28 10/10/07

(S)

(P)

10/01/07 (3)

(B) 013

Work Order ID 53712

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Page 4

Item ID: D3594-043

Revision ID: B

Item Name: Floor Doubler Assembly, LH

Start Date: 13/11/2009 Start Qty: 7.00

Required Date: 20/11/2009 Req'd Qty: 7.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location *23413*

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-1-7

sl (32)

10/01/07

mf 10-01-07

Picklist Print

November 13, 2009 9:56:11 AM

Page 1

Work Order ID: 53712



Parent Item: D3594-043RevB

Parent Item Name: Floor Doubler Assembly, LH

Start Date: 13/11/2009

Required Date: 20/11/2009

Start Qty: 7.00

Required Qty: 7.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Loc Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-4 		Purchased	No			100	Each	3,000.000	14.0000		9/11/30	8x
Rivet												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
STC	3000	
15541	3000	
	170	sf

M6061T6S.080 Purchased



6061-T6 .080 Sheet

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	194.45987	
107904	0.02	
110254	1.5	
110630	38.0926	
112040	0.0437	
112141	9	
112512	0.2784	
112763	145.52517	

14x

9-11-18

8

110630 x 1 = 38.09

112763 x 7 = 808.91

Picklist Print

November 13, 2009 9:56:11 AM

Work Order ID: 53712



Parent Item: D3594-043RevB

Parent Item Name: Floor Doubler Assembly, LH

Start Date: 13/11/2009

Required Date: 20/11/2009

Start Qty: 7.00

Required Qty: 7.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21069-5

Purchased

No

170

Each

20.0000

7.0000



Anchor nuts



9/11/30

8x 50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

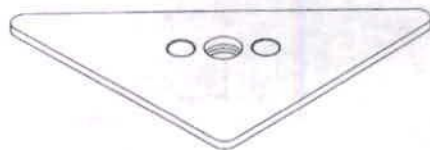
ST

111310

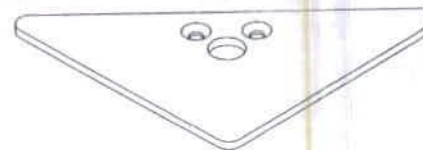
20

20

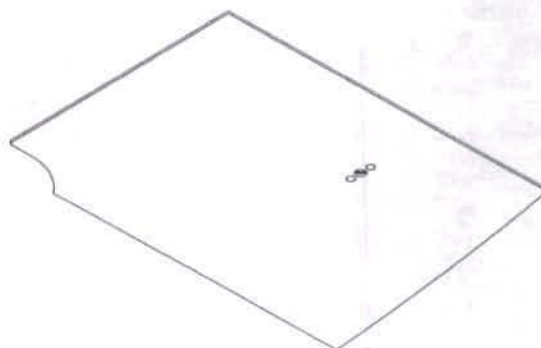
3x 50



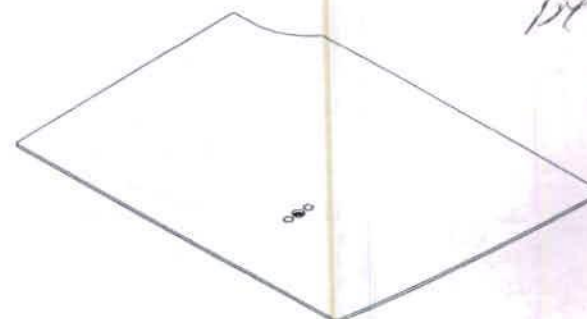
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



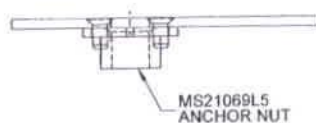
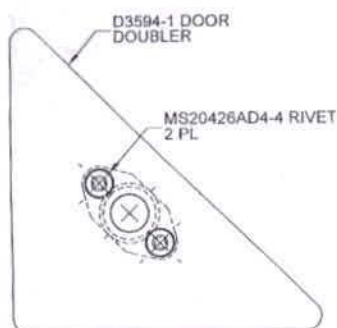
D3594-044 FLOOR DOUBLER ASSEMBLY

NO. 53712
 PL 09-11-13

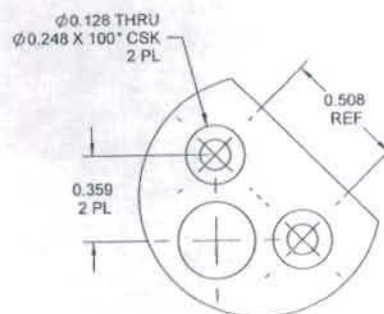
RELEASED
 0812 36 11

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD-5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ALL RIGHTS ARE RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	

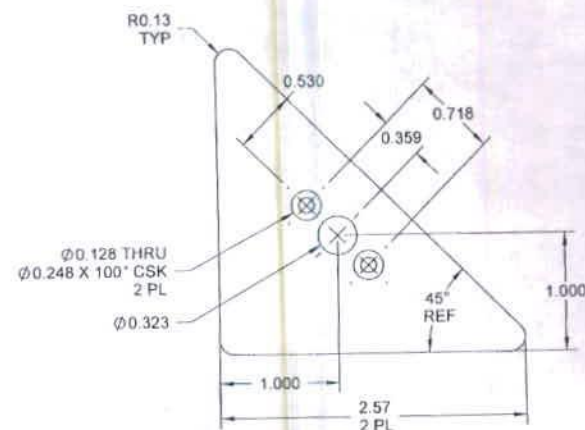
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



④ **D3594-041 DOOR DOUBLER ASSEMBLY**



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



⑤ **D3594-5 DOOR DOUBLER**

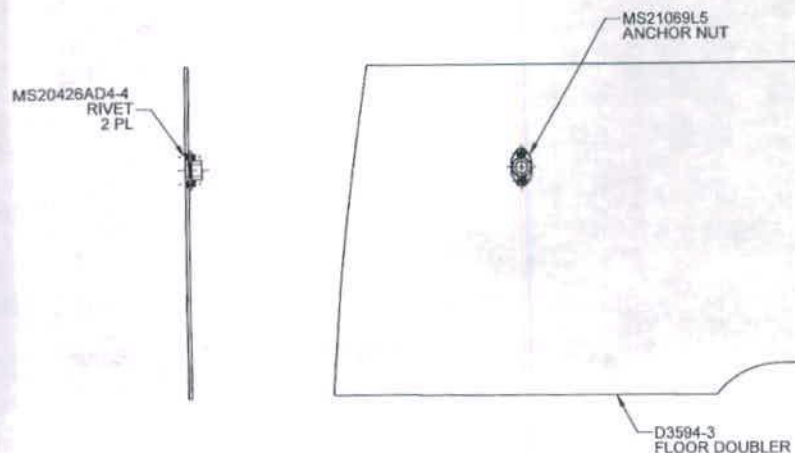
NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

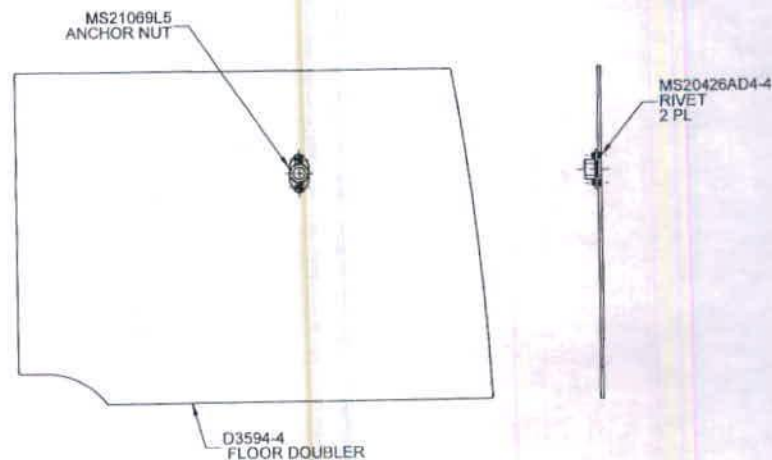
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DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
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DE APPR.		DOUBLER	NTS
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RELEASED
28-06-26-14

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 3 OF 4
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